



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2435

Job Sheet 166773



Part No: D2435

Job Qty: 10 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 10/27/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	10 Ea		10/26/17	0.00	0.00	Start up container	
120	Waterjet	10 pcs		10/26/17	0.00	1.86	Waterjet1	
130	CNC Vertical Machining	10 pcs		10/27/17	0.41	10.14	HAAS 1	SL
150	QC	10 pcs		10/27/17	0.00	0.00	QC8	my
151	Packaging	10 pcs		10/27/17	0.00	0.00	Packaging3	SL
190	QC21-SA	10 Ea		10/27/17	0.00	0.00	QC21	ML5 17-11-01

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	32	231	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053		
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle	
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470		
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170		
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220		
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595		
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240		
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	Angle	
10	Bearpaw	0.375Inches ± 0.010	0.385		

			0.365	
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	
12	Bearpaw	0.950Inches $+ 0.030$ $- 0.010$	0.980 0.940	
13	Bearpaw	0.260Inches $+ 0.005$ $- 0.000$	0.265 0.260	Diameter
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter
15	Bearpaw	0.300Inches $+ 0.030$ $- 0.000$	0.330 0.300	
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	

Plex 10/18/17 10:47 AM dart.Michaud-Febrille.Victoria

DART
AEROSPACE
S000987



Bearpaw

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D2435
Revision:
Operation: Start up Operation
Quantity: 10
Change No:

Mfg Date: 10/18/17
Job No: 166773

DART AEROSPACE LTD		Work Order: 166773
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010					
B	5.500	+/-0.030					
C	0.200	+/-0.030					
D	R0.250	+/-0.030					
E	0.250	+/-0.010					
F	0.625	+/-0.030					
G	0.25 x 45°	+/-0.030					
H	0.375	+/-0.010					
I	19.000	+/-0.030					
J	0.950	+0.030/-0.010					
K	Ø0.260	+0.005/-0.000					
L	Ø0.930	+/-0.030					
M	0.30	+0.030/-0.000					
N	0.375	+/-0.030					
O	7.375	+/-0.030					
P	4.250	+/-0.010					
Q	2.000	+/-0.030					
R	9.000	+/-0.010					
S	15.750	+/-0.030					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060x45°	✓		Ver ED-6	
B	5.500	+/-0.030	5.502	✓		"	
C	0.200	+/-0.030	0.192	✓		Depth gauge Gk-op	
D	R0.250	+/-0.030	R0.250	✓		R.G.	
E	0.250	+/-0.010	0.259	✓		Ver ED-C	
F	0.625	+/-0.030	.634	✓		"	
G	0.25 x 45°	+/-0.030	.250x45°	✓		"	
H	0.375	+/-0.010	.385	✓		"	
I	19.000	+/-0.030	19.000	✓		TAPE	
J	0.950	+0.030/-0.010	0.962	✓		Ver ED-6	
K	Ø0.260	+0.005/-0.000	0.260	✓		"	
L	Ø0.930	+/-0.030	0.932	✓		"	
M	0.30	+0.030/-0.000	.315	✓		"	
N	0.375	+/-0.030	.378	✓		"	
O	7.375	+/-0.030	7.385	✓		Ver CAX02	
P	4.250	+/-0.010	4.254	✓		Ver ED-6	
Q	2.000	+/-0.030	2.000	✓		"	
R	9.000	+/-0.010	9.001	✓		Ver CAX02	
S	15.750	+/-0.030	15.750	✓		TAPE	

Measured by: S.C.	Audited by: [Signature]	Prototype Approval:	N/A
Date: 17/10/25	Date: 17/10/28	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF [Signature]	[Signature]